

Standard Sterling Silver Plus 優質 925 銀

Product No./產品型號: ASM 1101-928

銀合金特性 928 Silver Alloy Characteristics

Density 密度 (g/cm ³)	10.34
Hardness 硬度 – As Cast (Hv) 熔鑄後	84
Hardness 硬度 – Heat Treated (Hv) 熱處理後	130
Hardness 硬度 – For sheet or wire (Hv) 壓片或拉線後	160
Excellent cast brightness	優異的澆鑄亮度
Similar casting properties to regular sterling, high hardness	鑄造性能類似一般 925 銀，高硬度
Medium tarnish resistance	中抗氧特性
Spring alloy/good casting and rolling alloy	彈簧合金或澆鑄和滾製用合金
Good for sheet and wire	適用於壓片及拉線用

建議鑄造參數 Recommended Investment Casting Parameters

Casting Temperature Range (°C) 澆鑄溫度範圍	Open systems 開放環境	950-1010
	Closed systems 密封環境	980-1010
Flask Temperature Range (°C) 燒粉溫度範圍		540-650
Quench Time (min.) 淬火時間		15-20
Re-alloying Scrap Percentage(%) 合金翻新比例		60% (new 新)

熱處理 Heat Treatment

Heat pieces in an oven to 625°C for 30 minutes, then quench while red hot in clean water. Clean/pickle pieces and pre-finish. Heat pieces in an oven to 260°C for 3 to 4 hours (thick pieces heat treat better at 375 °C). Remove pieces from the oven and air cool slowly.

將鑄件放在熱爐中並加熱至 625°C，放 30 分鐘，然後在金屬還是熱紅時放在乾淨的水中淬火。清潔或酸洗鑄件。將鑄件放在熱爐中並加熱至 260°C，放 3 至 4 小時(厚的鑄件建議使用 375°C 溫度作熱處理)。從熱爐中取出鑄件，放在空氣中慢慢冷卻。

建議首飾樹的清潔及風乾步驟

Recommended Cast Tree Cleaning and Drying Procedure

Use 10% nitric acid and 90% heated water for pickling. Rinse well with cool water to remove any remaining investment powder and base metal oxides. Dry with compressed air. Do not dry trees in any type of furnace!

請用 10%硝酸加 90%熱水作酸洗用。之後再用清水作徹底清潔，最後用壓縮空氣吹乾。切勿把首飾樹放進任何爐具烘乾!

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